

Date: Thursday, 18/06/2009 2:47:05 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HAT BIN, 206 L3/L4, GREY
Job Number : 48640A	
Estimate Number : 13976	
P.O. Number :	Part Number : D38501KGY
This Issue : 18/06/2009 S.O. No. :	Drawing Number : D3850-1
Prsht Rev. : NC	Project Number :
First Issue : / / Type : THERMOFORMING	Drawing Revision : B
Previous Run :	Material : MKYD6185S125P352068
Written By :	Due Date : 24/06/2009 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est. Rev. A New Issue 09/06/02 DL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S125P352068	6185 Kydex 125" steel grey
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Comment: Qty.: 11.4144 sf(s)/Unit Total : 11.4144 sf(s)
 6185 Kydex .125" Grey

M 111807 BB 09/06/28

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/06/18 (X1)

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

WH 09/06/18

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3850 and folio (FTA9338 Prototype) using tool DT 9338

Dwg. Rev. C

Folio Rev. B

BB 09/06/18 (X1)

Process Sheet

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Drawing Name: HAT BIN, 206 L3/L4, GREY

Job Number: 48640A

Part Number: D38501KGY

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/06/18 (X1)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PL 09/06/18

~~09/06/18~~

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Wh. 09/06/18

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

OL 09/06/18

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/06/04 (X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1st THERMOFORMING
Waiting for Packaging

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24

Job Completion



W 09/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3850-1 KG4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: AS Date: 10.01.24
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>48640A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/24	7	DRAWN POSITION OF HAT B/W THIN4 SORT	AS 09-06-24	REINFORCE AFFECTED AREA. PAR ATTACHED INSTRUCTION BASED OSTR-D407-781 RAJA.	BB 09/06/24	S 09/06/24	AS 09.06.24	S 09/06/24

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 48640A
Description:	Part Number: D3850-1K
Inspection Dwg: D3850 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DL</u>	Date: 09/06/18
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TRIMMING SECTION

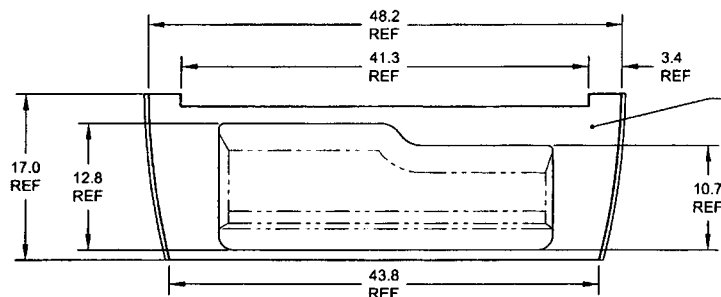
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.55"	MIN	0.619	✓			
0.055"	MIN.	0.110	✓			
0.030"	MIN.					see attached

Measured by: <u>DL</u>	Date: 09/06/24
Audited by: <u>BB</u>	Date: 09/06/24
Prototype Approval:	Date:

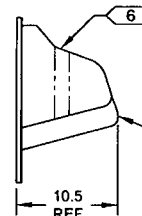
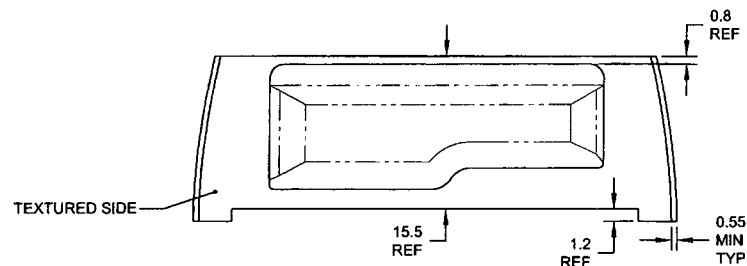
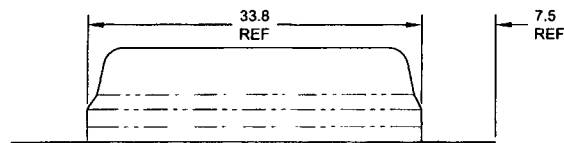
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

[Handwritten signature]

8 7 6 5 4 3 2 1



MIN FLANGE THICKNESS 0.055



MIN THICKNESS IN DRAWN PORTION IS 0.030

D3850-1 HAT BIN
(BELL 206 L3/L4)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9338 PER DART QSI 022. TRIM PER MOLD



PART NUMBER	DESCRIPTION
D3850-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.125-P3-62015)
D3850-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.125-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N D3850-1KIV AND ADD STEEL GRAY P/N D3850-1KGY (ZN A5-1)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1) REASON: TO IMPROVE DURABILITY	PH	09.02.19
A	NEW ISSUE	PH	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3850 HAT BIN (BELL 206 L3/L4) COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
09/05/22 NMP

8 7 6 5 4 3 2 1

With reference to Test Report, TR-D407-781-1 Rev. A, the following may be performed to reinforce the drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.

Kydex 6185 reinforced with 9 oz cloth using Hysol 9330 A/B and ATH208
Procedure:

- 1) Abrade smooth side of Kydex 6185 with scotchbrite and clean with acetone
- 2) Mix Hysol 9330 – Part A to Part B – 100% to 33% by weight in accordance with manufacturer's instructions

Hysol 9330 (2 part system)

BATCH # M 112099

- 3) Mix item 2) with ATH208 (Aluminum TriHydrate) at 50% by weight

ATH208

BATCH # M 110065

Ex:

100 grams of Hysol 9330 Part A + 33 grams of Hysol 9330 Part B = 133 grams of Hysol 9330

Therefore, use 133 grams of ATH208

- 4) Saturate 1 layer of 7781 9oz glass Cloth (item # FG778150550ROL) with mixture of Hysol 9330 and ATH208

9oz glass Cloth

BATCH # M 11166

- 5) Apply item 4) to reinforce drawn portion of the D3824-1/-3, D3835-1, D3845-1, D3850-1 Hat Bins.
- 6) QC 5

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RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42640A